



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3969-1

Job Sheet 172547



Part No: D3969-1

Job Qty: 6 ea

Part Name: Spring (Basket Lid)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/13/18

Created By: Diane Baker

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B as per revC DD 10.03.16 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	6 pcs		3/13/18	0.00	0.00	Purchasing		AT 18/02/28
110	Packaging	6 pcs		3/13/18	0.00	0.00	Packaging2		AT 18/02/28
120	QC	6 pcs		3/13/18	0.00	0.00	QC6		11 38 MAR 01 2018
122	Small Fab	6 pcs		3/13/18	0.00	0.00	Small Fab-5		9-89 9-89
124	QC	6 pcs		3/13/18	0.00	0.00	QC5 N/A		
130	Packaging	6 pcs		3/13/18	0.00	0.00	Packaging3-2		
140	QC21-SA	6 Ea		3/13/18	0.00	0.00	QC21		MAR 13 2018

Part Op 100 - Issue P/O: 039670 Order as per Dwg D3969 Possible supplier: LS Technologies part#: SSA4/6-122-315-310N

Descriptions: 315-310N

110 - ***Measure compression only at 5mm on gas spring***

120 - ***Measure compression only at

122 - CRIMP END FITTING AT LOCATION SHOWN ON DWG (SEE NOTE 8)

FEB 20 2018

21 MAR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SSA4/6-122-315-310N	Gas Spring D3969-1	6 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	SSA4/6-122-315-310N	6	0	0

Part Specifications

Specifications could not be found.

Plex 2/20/18 11:37 AM dart.baker.diane

CONTAINER NO.

00-10000

(Not Lid)

Spring (Basket Lid)

PART NO: D3969-1
Lot No/Batch: S046603

PART NO: B000000000
Serial No/Batch: S046603

Revision:

Operation:

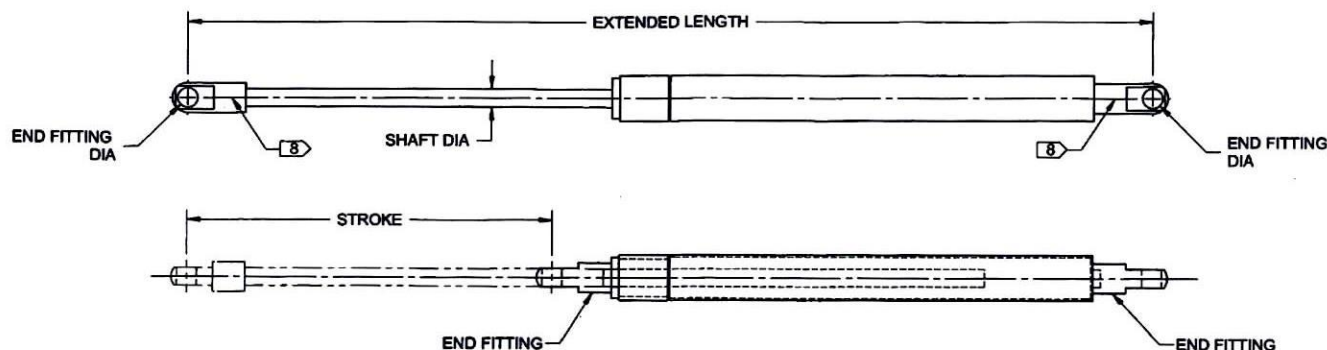
Change No:

Packaging

Mfg Date: 02/28/18

Job No: 172547

SPECIFICATION CONTROL DRAWING



D3969-X SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	122/4.80	315/12.40	8/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	122/4.80	315/12.40	8/0.31	380/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	122/4.80	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs
D3969-7	122/4.80	315/12.40	6/0.24	222/50.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-225N	0.27 lbs
D3969-9	130/5.12	343/13.50	8/0.31	380/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-130-343-360N	0.35 lbs

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

D	ADDED -7/-8	ML	16.05.12
C	REDRAWN IN SW, ADDED -3 & -5, ADDED SHAFT DIA COLUMN TO CHART, FORCE FOR -1 CORRECTED (WAS 60.0 lbs)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID), NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3969	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET LID SPRING	NTS
DATE	16.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-05-19
EAL 16-581

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039070

Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO039070
PO Date: 2/20/18
Due Date: 3/13/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
FEB 21 2018

copy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed	3/13/18	6 pcs	0 pcs	6 pcs	\$51.12/pcs	\$306.72
Line Item Note job# 172537											
2	B6-190-475-070N			Door Prop D3552-23 As per Dwg D3552 Rev. L	Firmed	3/13/18	6 pcs	0 pcs	6 pcs	\$32.50/pcs	\$195.00
Line Item Note job# 172539											
3	B8-154-387-156NX			Gas Spring D3552-17 As per Dwg D3552 Rev. L	Firmed	3/13/18	6 pcs	0 pcs	6 pcs	\$26.50/pcs	\$159.00
Line Item Note job# 172540											
4	B8-220-530-070N			Carbon Steel Gas Spring D3552-7 As per Dwg D3552 Rev. L	Firmed	3/13/18	10 pcs	0 pcs	10 pcs	\$29.48/pcs	\$294.80
Line Item Note job# 172543											
5	SSA4/6-122-315-310N			Gas Spring D3969-1 As Per Dwg D3969 Rev. D	Firmed	3/13/18	6 pcs	0 pcs	6 pcs	\$51.85/pcs	\$311.10
Line Item Note job# 172547											
Grand Total:										\$1,266.62	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION

CL
db



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Feb 22, 2018

This is to certify that the parts listed below meets specifications as required by your order.

6 Units: D2807-041 #172537 Stainless Gas Spring

6 Units : D3552-23 #172539 Gas Spring

6 Units : D3552-17 #172540 Gas Spring

10 Units : D3552-7 #172543 Gas Spring

6 Units: D3969-1 #172547 Stainless Gas Spring

Country of Manufacture: Canada
Date of Manufacture : Feb 2018
This product is ROHS compliant.

Purchase Order # 039070
Invoice # 17985

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President